

Ship 25-26/05

Work Order ID 58965

May 20, 2010 11:59:51 AM



Page 1

Item ID: D3955-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Template

Start Date: 5/20/10

Start Qty: 3.00



Cust Item ID:

Required Date: 5/25/10

Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3955

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3955

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

B 10-5-20

③

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-5-20

Work Order ID 58965

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Page 2

Item ID: D3955-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Template

Start Date: 5/20/10

Start Qty: 3.00



Cust Item ID:

Required Date: 5/25/10

Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/05/25

(X3)

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

10-5-25-20 (38)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/25
R 10-5-25
(3)

Picklist Print

May 20, 2010 11:59:49 AM

Page 1

Work Order ID: 58965



Parent Item: D3955-23



Parent Item Name: Template

Start Date: 5/20/10

Required Date: 5/25/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No				sf	92.6000	0.3962			



6061-T6 .040 Sheet



B10-S-20

Location

Loc Qty

Loc Code

MAT21

92.6

113004

92.6

113004

3

DART AEROSPACE LTD		Work Order:	58965
Description: TEMPLATE		Part Number:	D3455-03
Inspection Dwg: D3455-03 Rev: A		Page 1 of 1	

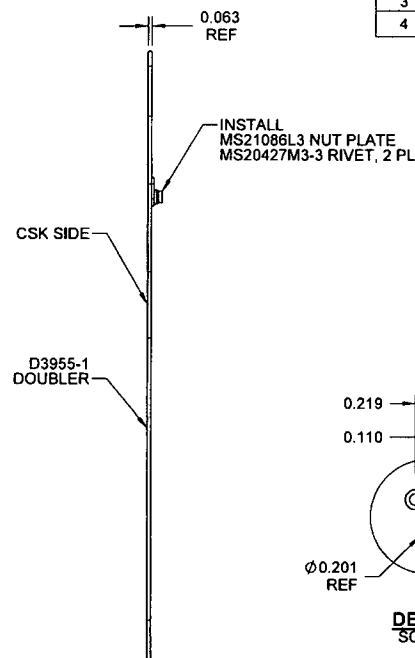
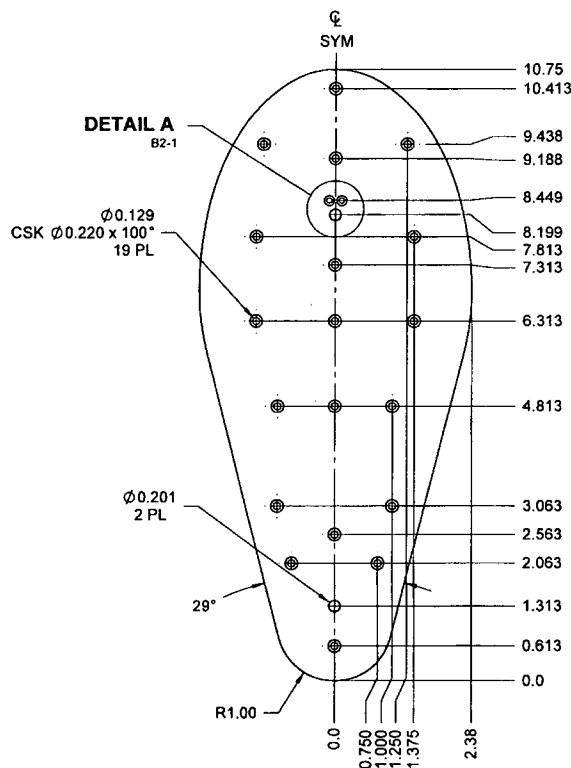
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	.004 - .001	1.00	✓			
Ø .129	.005 - .001	.131	✓			
.1750	± .010	.1748	✓			
1.000	± .010	.997	✓			
1.250	± .010	1.250	✓			
1.375	± .010	1.377	✓			
2.563	± .010	2.560	✓			
.800	± .010	.808	✓			
1.500	± .010	1.502	✓			
2.250	± .010	2.247	✓			
2.750	± .010	2.751	✓			
3.250	± .010	3.252	✓			
5.000	± .010	5.000	✓			
6.500	± .010	6.500	✓			
7.500	± .010	7.499	✓			
8.000	± .010	7.999	✓			
8.500	± .010	8.497	✓			
9.375	± .010	9.375	✓			
9.625	± .010	9.620	✓			
10.600	± .010	10.598	✓			
11.13	± .030	11.126	✓			
1.040	± .010	1.038	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-5-23	Date: 10/5/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



ITEM	QTY	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET

D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

RELEASED
016722 MB

A		NEW ISSUE		RF	09.07.21
REV.	DESCRIPTION			BY	DATE
DESIGN	DS	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	D3955	REV. A	
MFG. APPR.		TITLE	SKIDTUBE TUNING KIT	SCALE	
APPROVED		DATE	09.07.21	NTS	
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8 7 6 5 4 3 2 1

D

C

B

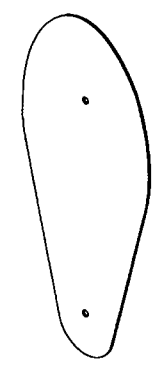
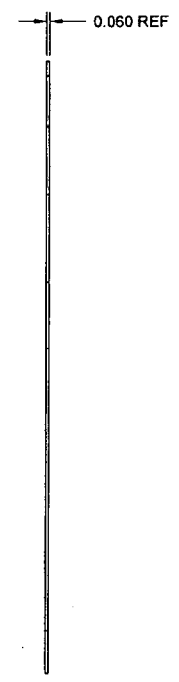
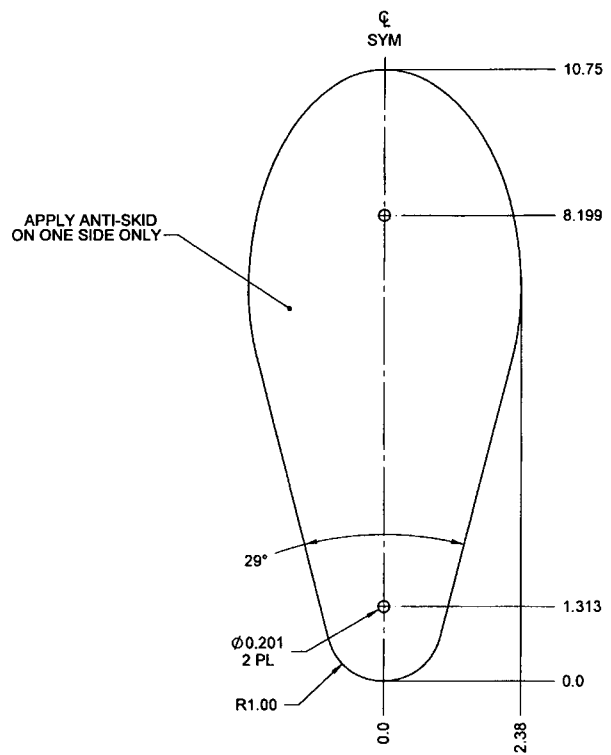
A

D

C

B

A



D3955-3 COVER PLATE

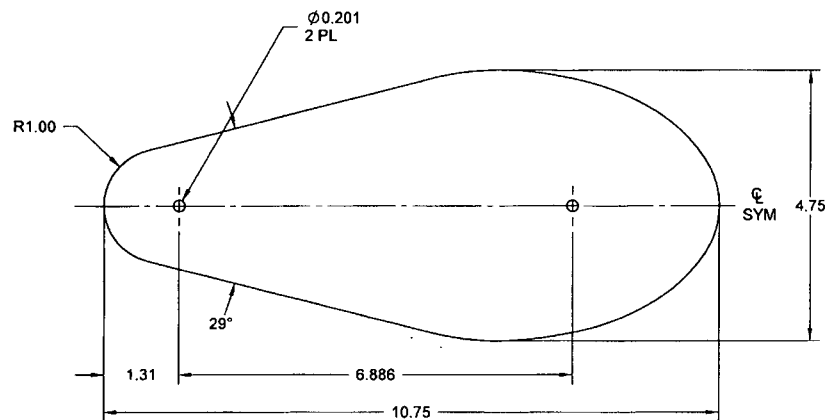
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
 - 2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.64 lbs

all 58965

RELEASED
9/12/21

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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8 7 6 5 4 3 2 1



D3955-X PLATE

General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

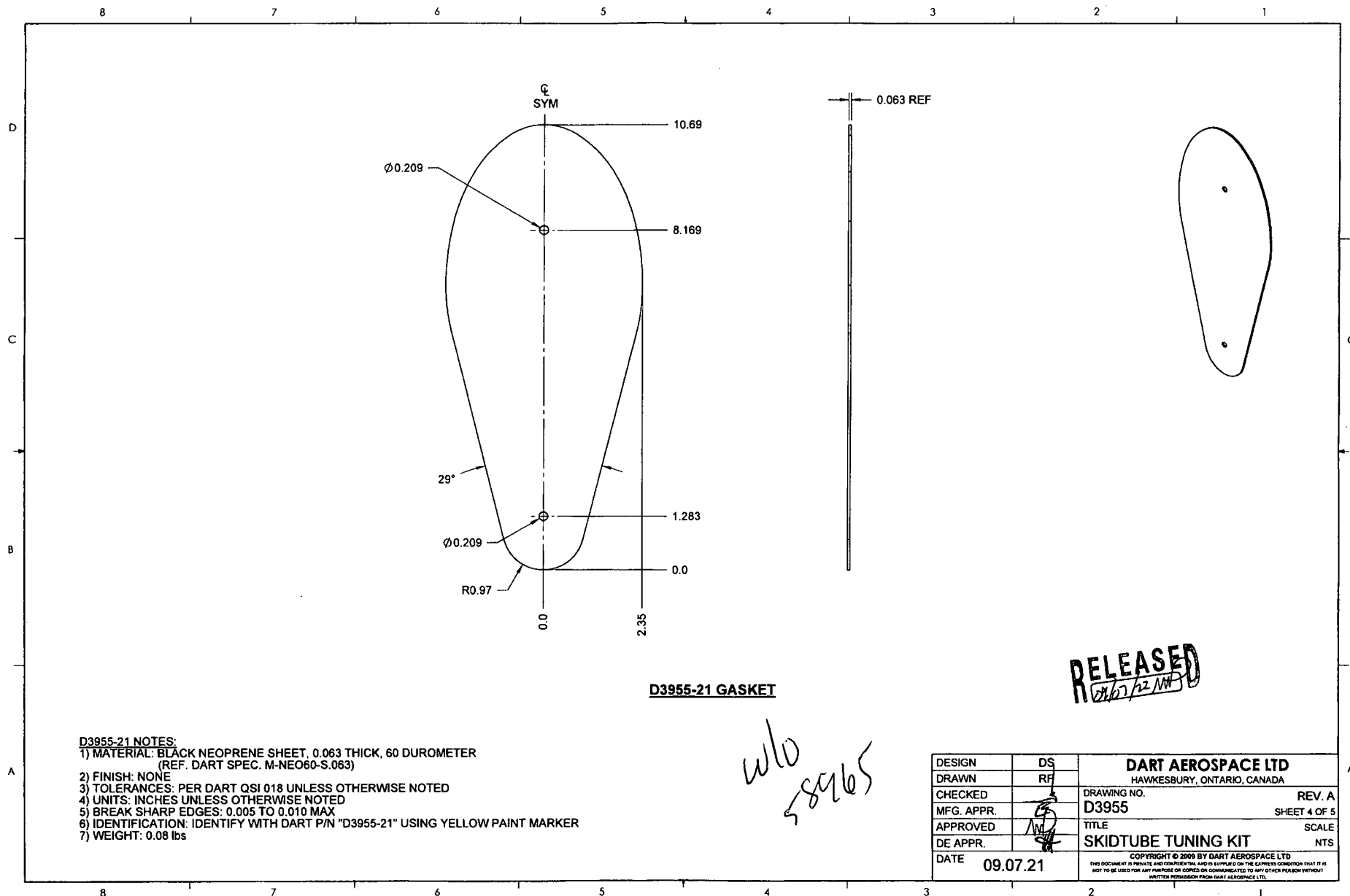
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304STGA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

RELEASED
6/10/22 MDD

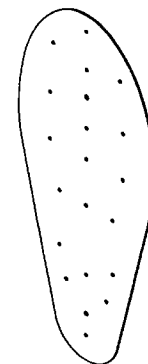
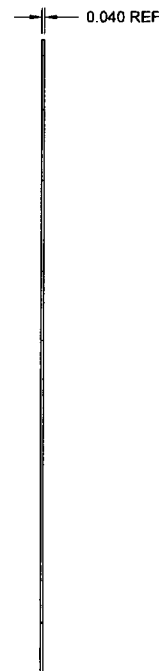
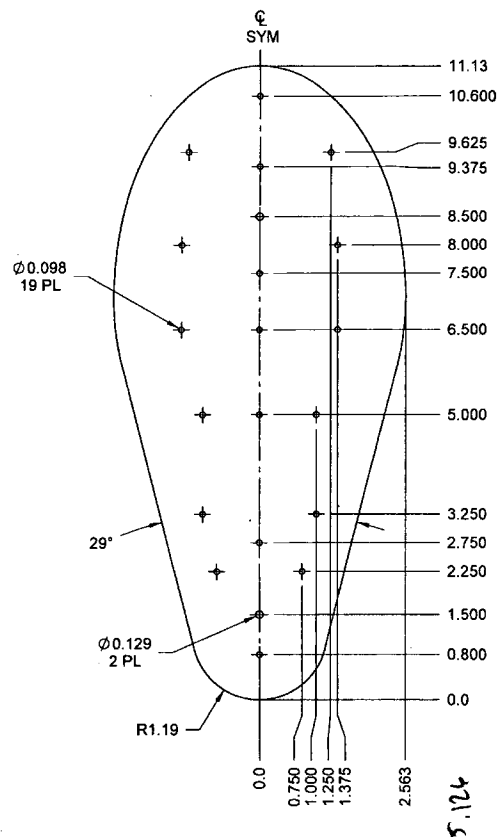
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MFG. APPR.		D3955	SHEET 3 OF 5
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58465



RELEASED
 07/07/22 NW

wlo
 58965



D3955-23 TEMPLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

*WV
58965*

RELEASED
01/07/22 MFB

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APPROVED		TITLE	SCALE
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